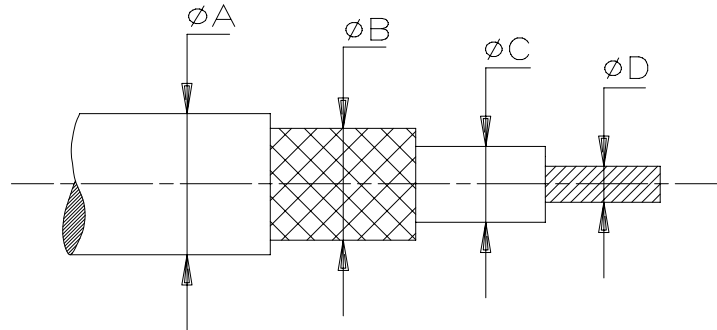


Installation Procedure for Coaxial Cable Splice Kit B-202-81 and B-202-82

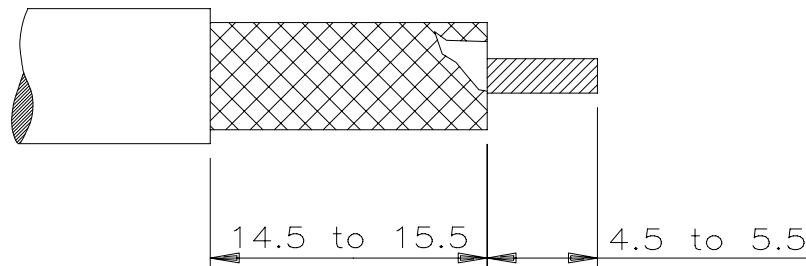
1. Cable Dimensions:



Part Number	øA	øB	øC	øD
B-202-81	3.7 to 6.8	3.4 to 4.8	2.5 to 3	0.3 to 1.2
B-202-82	4.2 to 6.8	4 to 5	3.1 to 3.7	0.5 to 1.2

2. Cable Preparation:

- Prepare the cable as shown (braid is cut flush with end of dielectric).



- The minimum space required to be able to install the splice is 120mm.

3. Application Equipment and Tooling:

3.1 Holding fixture: AD-1319 to maintain alignment.

3.2 Heating tool: Hot air heater: CV-1981 with PR25D reflector, set on position 7⁽¹⁾,
 HL1910E with PR25D reflector, setting = 6 on dial⁽¹⁾ or HL2010E with PR25D reflector,
 700°F on LCD⁽¹⁾.

4. Assembly Procedure:

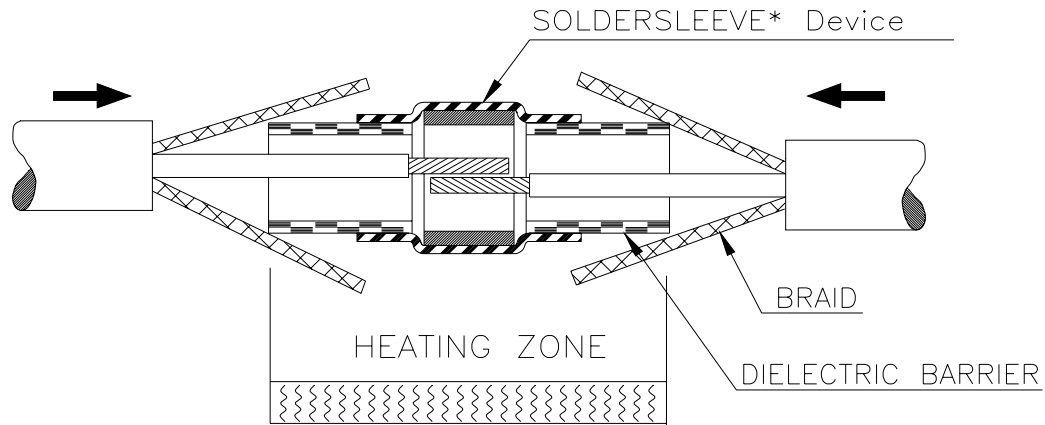
There are 3 components in this assembly:

- SolderSleeve Device
- Insulation Tubing
- SolderShield Device

4.1. Slide the SOLDERSHIELD device and the insulation tubing onto one of the cables.

4.2. SOLDERSLEEVE device.

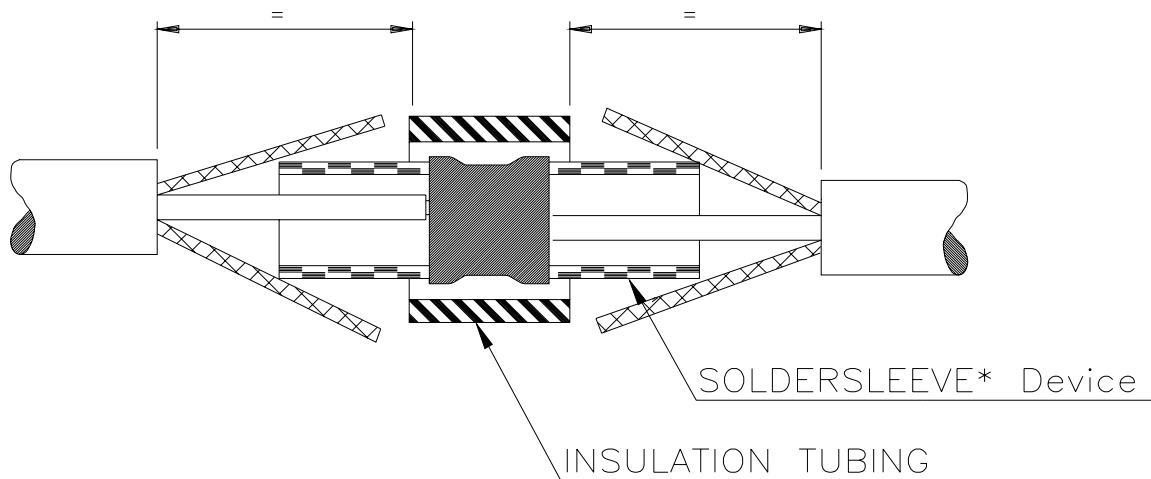
- Insert and position the center conductor of each cable into the SolderSleeve device. (Slide the dielectric barrier under the braid). See figure below.



- Apply heat to the solder preform until it melts, flows and creates a solder fillet between the conductors.
- Let the assembly cool down before handling.

4.3 Insulation Tubing:

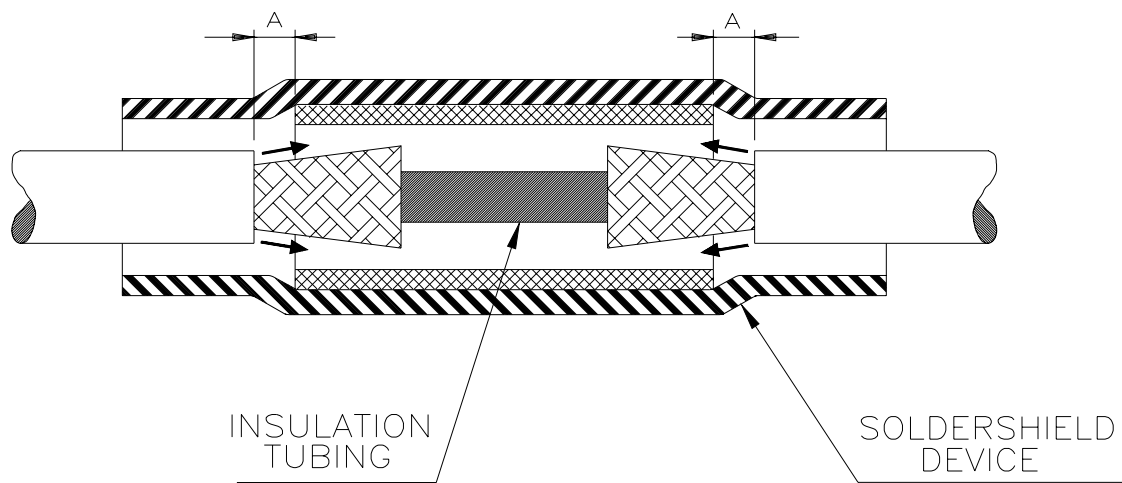
- Slide and center the black insulation tubing over the splice. See figure below.



- Apply heat to the insulation tubing until it shrinks down over the inner part.
- Let the assembly cool down before handling.

4.4 **SOLDERSHIELD** device.

- Smooth the strands of the braid so that they do not protrude.
- Slide and center the **SOLDERSHIELD** device over the cable braid. 'A' dimensions should be visually equal.



- Heat the SolderShield device. Start in the center and heat until the solder melts and the SolderShield recovers. Move the heat towards one end of the shield slowly enough to keep the sleeve recovering as you move along. Apply heat for an additional 5 to 10 seconds to the final 12.5mm (1/2") of the SolderShield to ensure sufficient heat transfer to the cable shield to make a good joint. Repeat for the other end of sleeve.
- Let the assembly cool down before handling.

¹ These values are for reference only and may change based on other variables (i.e. reflector type, sleeve's relative distance to the reflector, etc.)

DISCLAIMER

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